ABSTRACT OF THE DISCLOSURE

A method and a device for numerical control of machine tools, robots, production machines and the like, is described, whereby complex and large task can be processed more easily. This is realized by a numerical controller which can generate a marker signal, in particular desired position values for system components, in particular drives, at a certain interpolation clock cycle or rate. A control axis provides in an interpolation clock cycle reference values for reading a table, whereby desired position values for asynchronous successor axis can be obtained. The tables can also store switching functions that define start and end points independent of the interpolation clock cycle. As soon as the integration clock cycle has reached or exceeded the point in time of a reference value, execution of the functions stored in the table can be triggered. The table can be stored in encoded and/or non-encoded form.